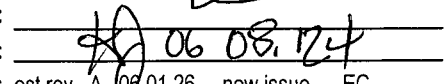


Date: Thursday, 8/24/2006 11:10:01 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LUG WELDMENT
Job Number :	28316		
Estimate Number :	12117		
P.O. Number :	N/A	Part Number :	D3353041
This Issue :	8/24/2006	Drawing Number :	D3353 REV.A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	25802	Material :	N/A
Written By :		Due Date :	8/31/2006
Checked & Approved By :			
Comment :	est rev A 08.01.26 new issue EC		

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D335311	universal joint
-----	---------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-11	universal joint	B27330

Cpl 06-10-16

2.0	D33535	back plate
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-5	back plate	B26813

Cpl 06-10-16

3.0	D335313	tubing
-----	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-13	tubing	B28328

Cpl 06-10-16

4.0	D335317	support
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3353-17	support	B28330

Cpl 06-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:10:01 AM
Usér: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 28316

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33533

right plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

✓
qty part number description batch
1 D3353-3 right plate B26804

CPL 06-10-16

6.0

D33539

STOP PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

✓
qty part number description batch
1 D3353-9 stop plate B28331

CPL 06-10-16

7.0

D33531

left plate



✓
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

qty part number description batch
1 D3353-1 left plate B26803

CPL 06-10-16

8.0

D33537

front plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

✓
qty part number description batch
1 D3353-7 front plate B26805

CPL 06-10-16

9.0

D335315

lock bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
pick:

✓
qty part number description batch
1 D3353-15 lock bracket B28329

CPL 06-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 8/24/2006 11:10:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 28316

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3353

Cpl 06.10.17

(4)

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

J 06/10/17 (4)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask part as per dwg D3353

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL 06 11 07 (4)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

am 06/11/07 (4)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: stol

06/11/08 (4)

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/11/09 (4)

Job Completion



06/11/09

WORK ORDER CHANGES							
PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

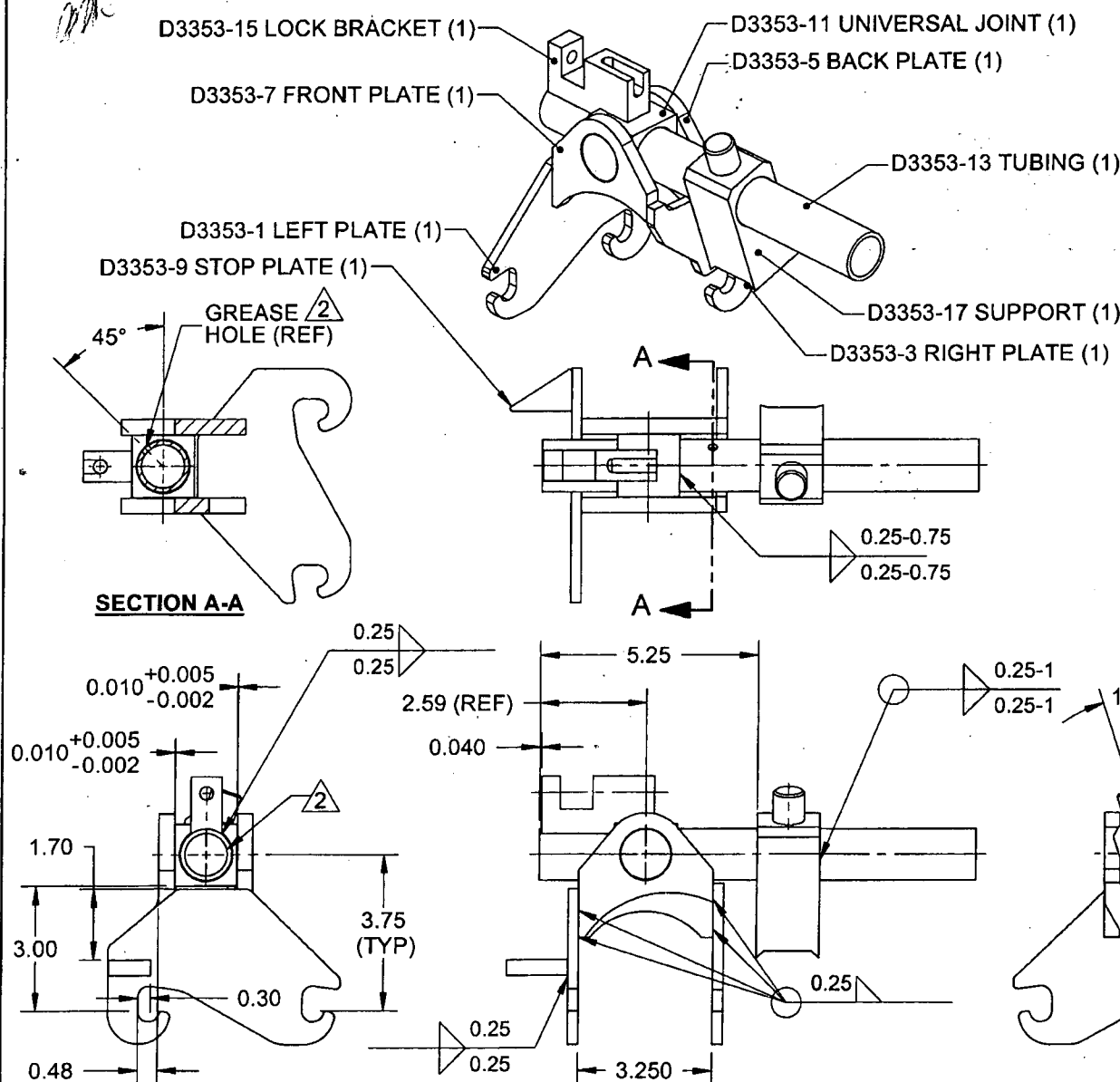
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
2-5-10

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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

**D3353-041 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

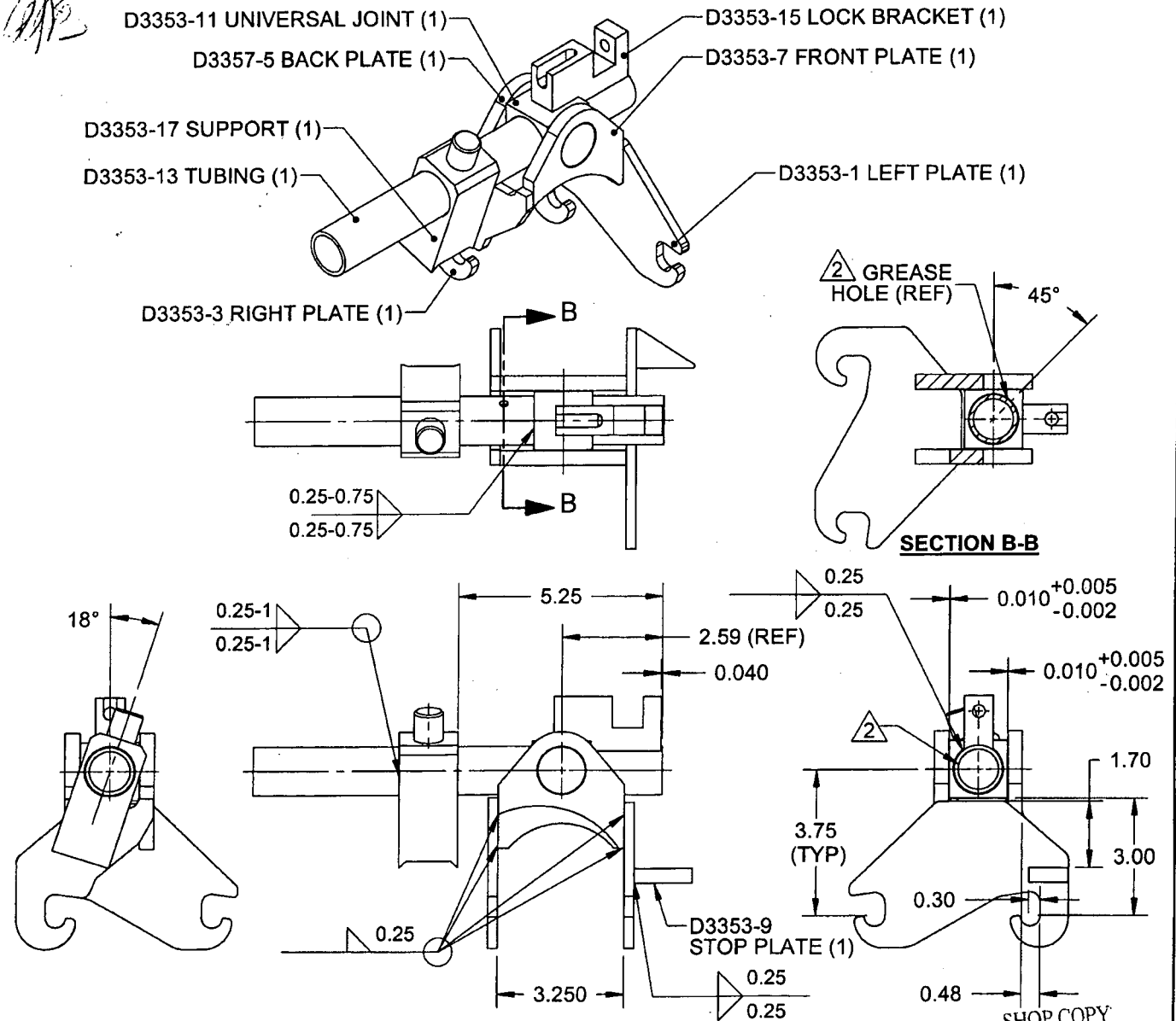
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4

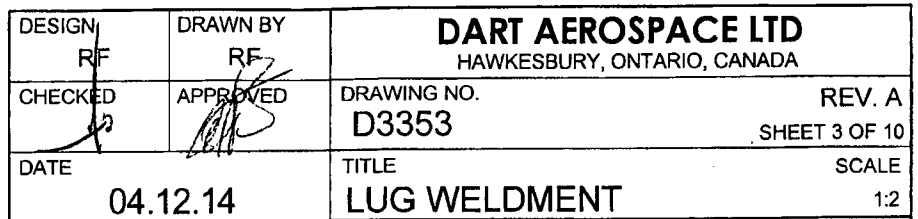
RELEASED
04/03/59**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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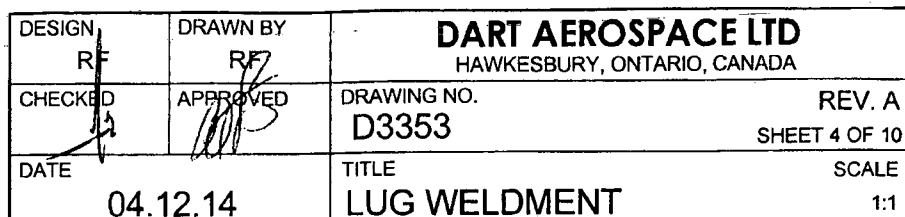
RELEASED
06/07/84



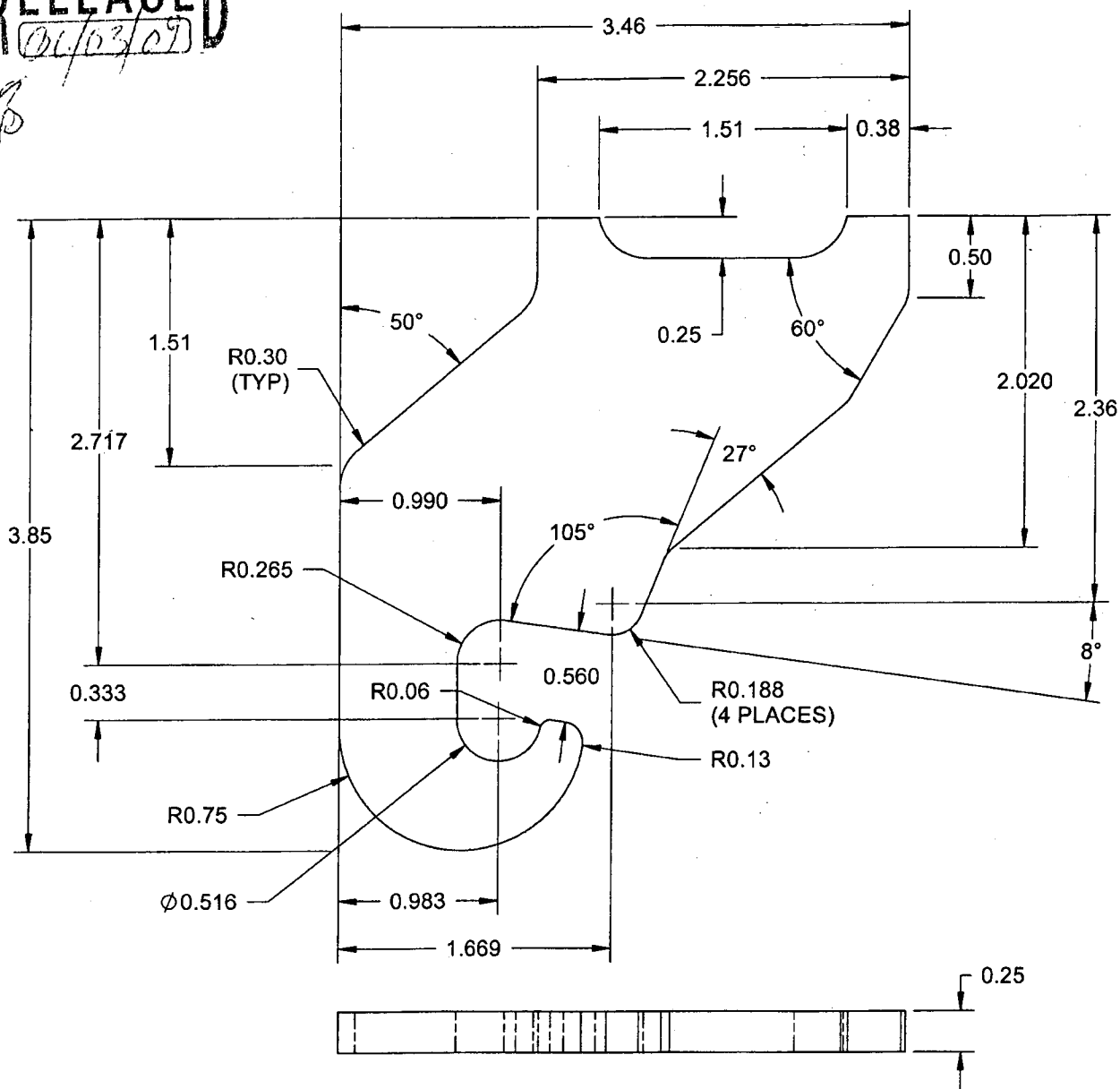
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, UN
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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06/03/07



D3353-3 RIGHT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

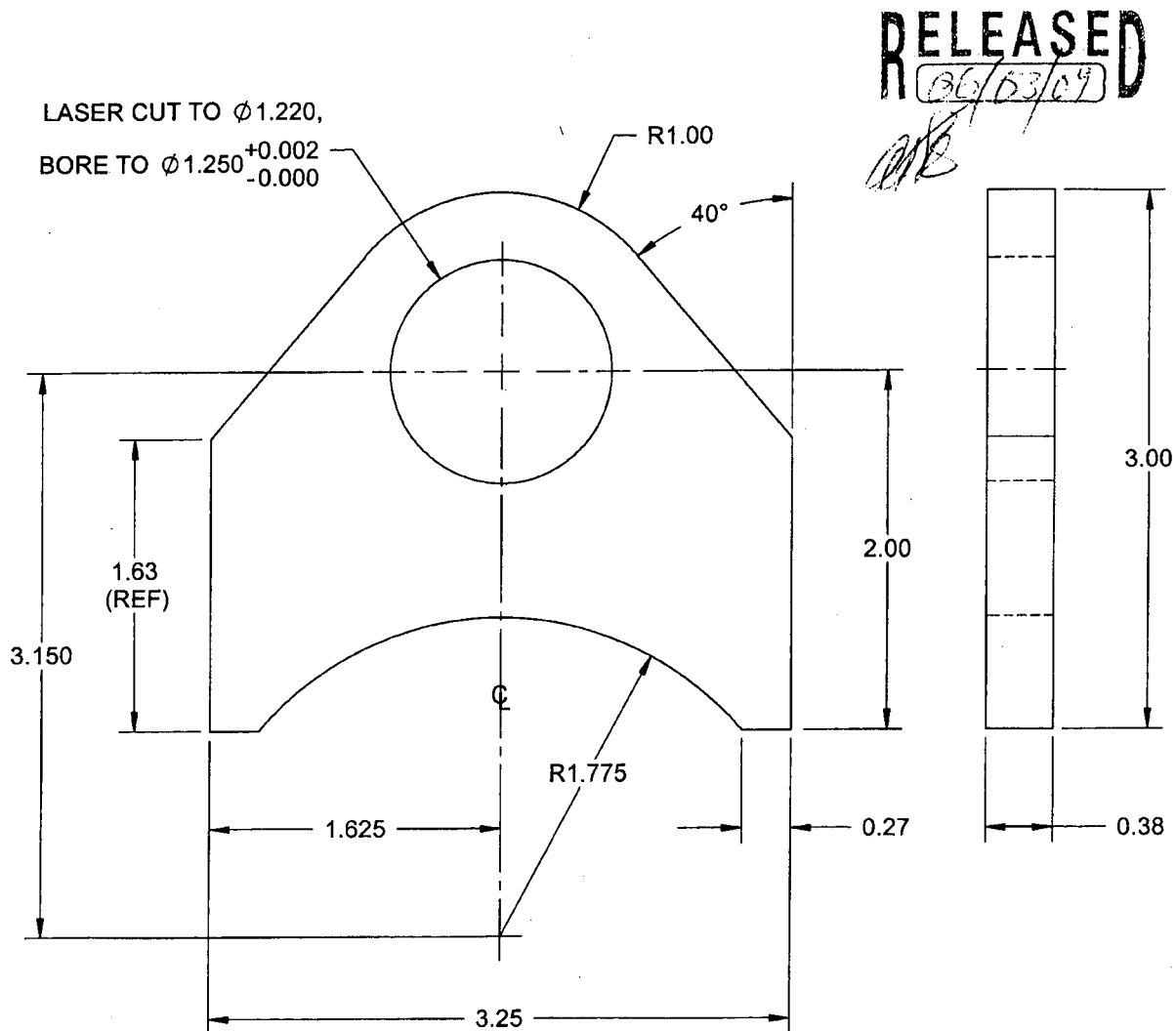
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DATE 04.12.14	TITLE LUG WELDMENT	SHEET 5 OF 10 SCALE 1:1	

**D3353-5 BACK PLATE****NOTES:-**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

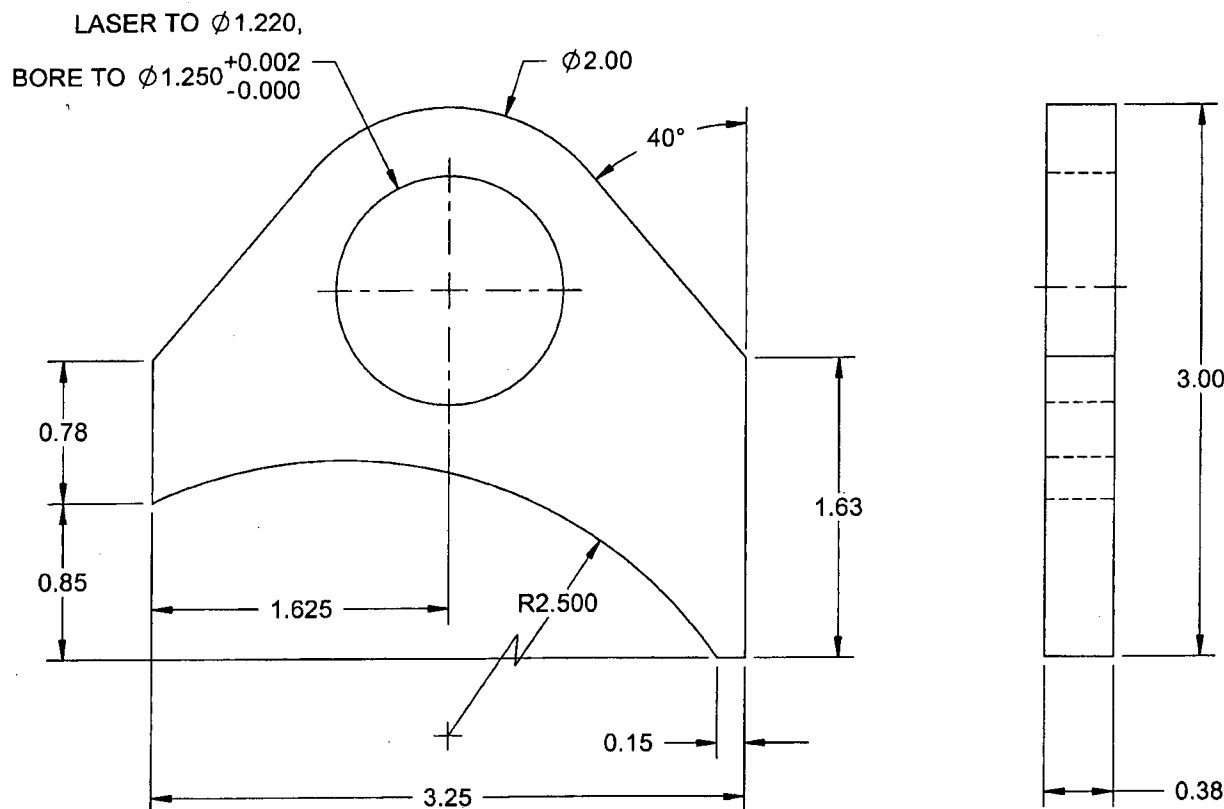
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DATE 04.12.14	TITLE LUG WELDMENT	SHEET 6 OF 10 SCALE 1:1	

RELEASED
04/12/14**D3353-7 FRONT PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

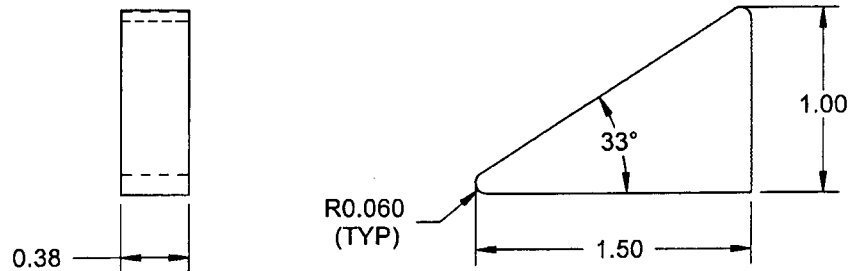
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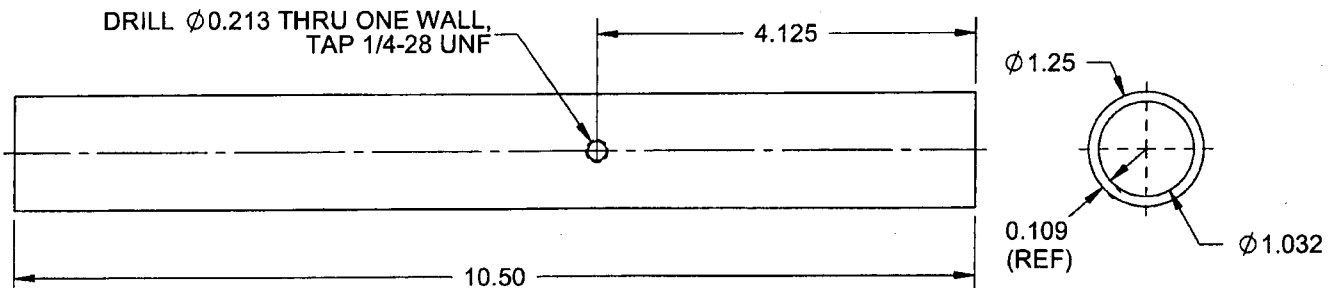
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
[Signature]**D3353-9 STOP PLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)

**D3353-13 TUBING****NOTES:**

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

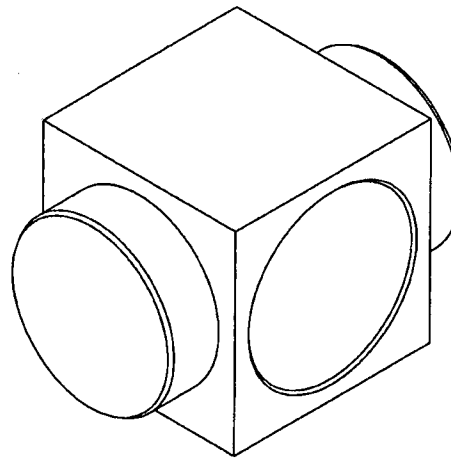
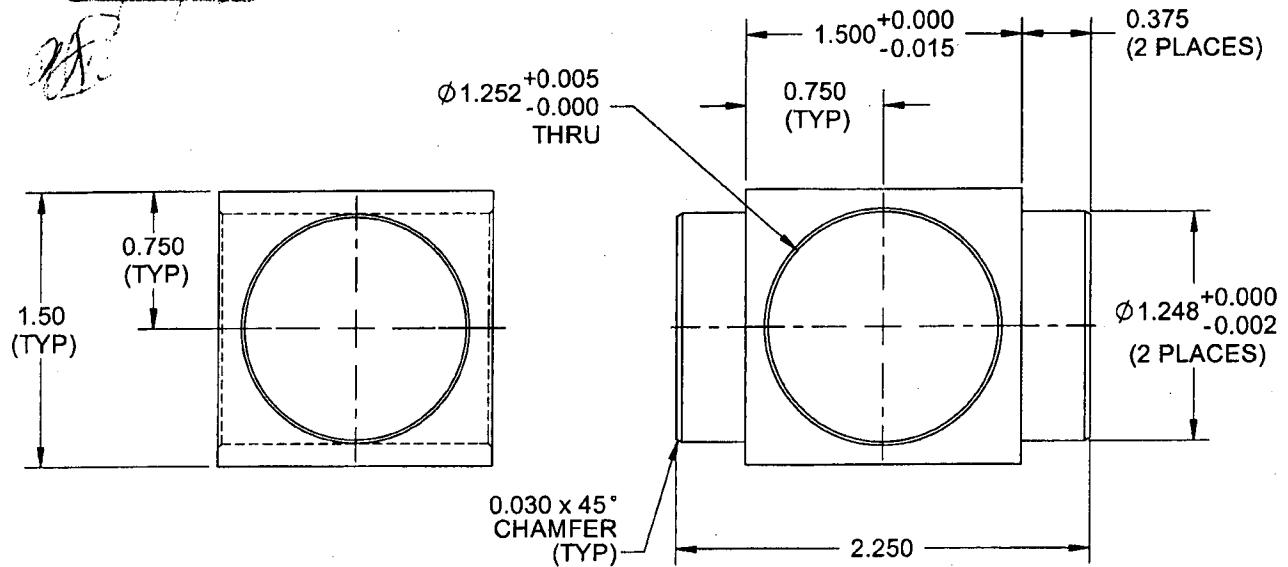
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/33/09**D3353-11 UNIVERSAL JOINT****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

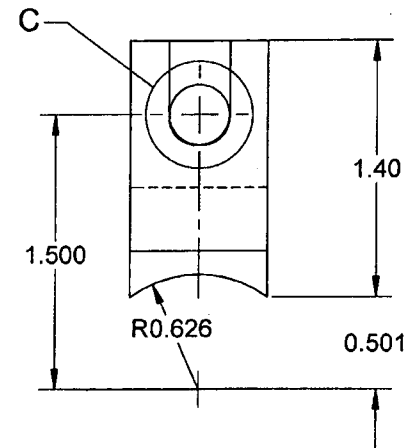
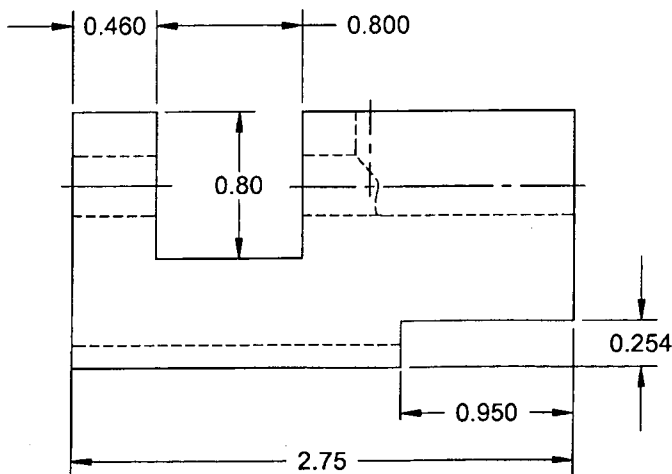
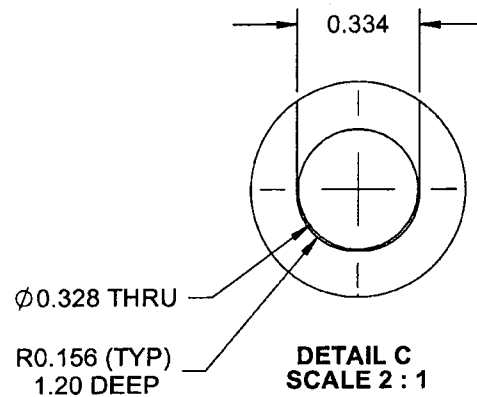
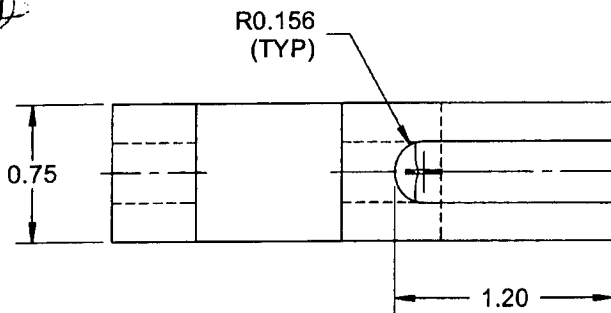
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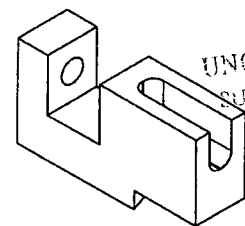
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
06/02/09**D3353-15 LOCK BRACKET****NOTES:**

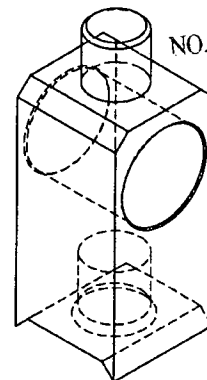
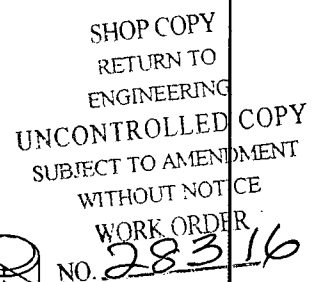
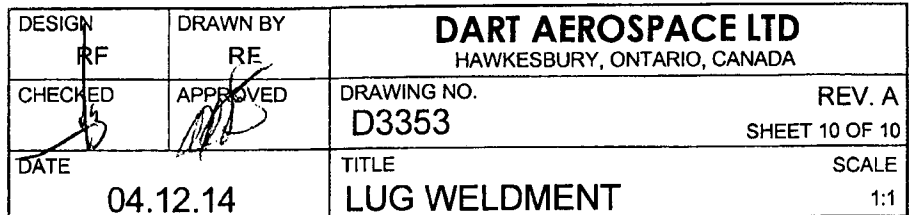
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW
SCALE 1:2**

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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD
STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
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